

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012573**Date Inspected:** 25-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

Tower Trial Assembly

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 044 located on North Tower Lift-1 Bearing stiffener Plate NSD1 – SA76F/M. Welder is identified as 066673. ZPMC Quality Control (QC) Inspector is identified as Liu Zhi. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.

Weld joint # 031 located on East Tower Lift-1 Bearing stiffener Plate SSD1 – SA40B/E. Welder is identified as 057180. ZPMC Quality Control (QC) Inspector is identified as Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.

Weld joint # 009 located on North Tower Lift-1 Bearing stiffener Plate NSD1 – SA22B/E. Welder is identified as 050041. ZPMC Quality Control (QC) Inspector is identified as Liu Zhi. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.

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BAY 10

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW):

Weld joint # 52A located on South Tower Lift-5 D/E corner SSD1 – TL5 – 1B – F. Welder is identified as 050289. ZPMC Quality Control (QC) Inspector is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U4b – 1.  
(See attached photo)

Repair welding of a weld joint # 5A according to the critical weld repair report #T-CWR-591 located on North Tower Lift-4 B/C corner NSTL4-3B/L. Welder is identified as 057258. ZPMC Quality Control (QC) Inspector is identified as Gong Liang Zhu. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 2G (2F) – Repair.

Weld joint # 39B located on South Tower Lift-5 C/D corner SSD1 – TL5 – 1B – F. Welder is identified as 052930. ZPMC Quality Control (QC) Inspector is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U4b – 1.

Sub-Merged Arc Welding (SAW):

Weld joint # 19A located on Grillage Plate ND1 – TL5 – 3B – F. Welder is identified as 050295. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3221 – B – U3c – S – 1.

BAY 11

This QA Inspector observed the following work in progress:

Sub-Merged Arc Welding (SAW):

Weld joint # 2-5B located on Strut Plate ED1 – STSA4 – 10 – 119M. Welder is identified as 040699. ZPMC Quality Control (QC) Inspector is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4221 – B – U3c – S – 1.

Weld joint # 1-2B located on Strut Plate ND1 – STSA4 – 10 – 119M. Welder is identified as 044550. ZPMC Quality Control (QC) Inspector is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4221 – B – U3c – S – 1.

Shielded Metal Arc Welding (SMAW):

Repair welding of a weld joint # 59A according to the weld repair report #T-WR-3071 located on West Tower Lift-4 A/B corner NSTL4-3B/L. Welder is identified as 053916. ZPMC Quality Control (QC) Inspector is identified as Shao Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 2G (2F) – Repair.

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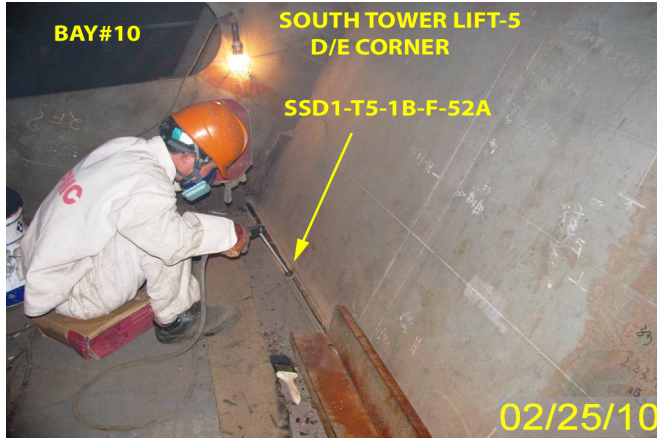
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(See attached photo)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No Relevant Conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Sandeep	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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